

Work Order ID 70388

Monday, June 06, 2011 10:38:51 AM



Page 1

Ship Today

Item ID: D120-639-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Tungsten Carbide Wearplate

Start Date: 6/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MMF Date: 11-06-06 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9223	Rev A
IIN-D120-639	Rev A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels per PPP D120-639-011 CHG 002

Sub 6/6

Hefar BG 11-6-6

105



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/6/6 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC4- 100% Inspect kits for completeness

0.00

Sub 6/6



QC

Memo

0.00

Quality Control

②

120

Packaging

0.00

Rept



Packaging

Memo

0.00

Packaging

Package and Identify as per PPP D120-639-011

11/6/06 ②

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/06
MK
11-06-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 06, 2011 10:38:49 AM

Page 1

Work Order ID: 70388

Parent Item: D120-639-011

Parent Item Name: Tungsten Carbide Wearplate

Start Date: 6/6/2011

Required Date: 6/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D 02.09.13 Re-format, Added MS27130-S30 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2746 -		Manufactured	No			105	Each	4.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Wearshoe

Location

Loc Qty

Loc Code

ST496A

4

46960

4

Manufactured

No

105

Each

6.0000

1

2

Location

Loc Qty

Loc Code

FP020

6

62203

6

Manufactured

No

105

Each

5.0000

1

2

D2656-13



Wearplate

Location

Loc Qty

Loc Code

FP020

5

57354

5

Purchased

No

105

Each

1,965.000

36

72

ALS7-1032-130



Insert

Location

Loc Qty

Loc Code

ST281

14

117331

14

ST282

1951

116800

1

117712

1950

14

1
52

11/6/6 sf 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, June 06, 2011 10:38:49 AM

Page 2

Work Order ID: 70388

Parent Item: D120-639-011

Parent Item Name: Tungsten Carbide Wearplate

Start Date: 6/6/2011

Required Date: 6/6/2011

Start Qty: 2.00

Required Qty: 2.00

D2648-3

Manufactured No

105

Each

22.0000

5

10



Wearpad

Location

Loc Qty

Loc Code

FG

12

45316

12

ST237

10

65824

10

MS27039-1-08

Purchased

No

105

Each

944.0000

40

80



Screw

Location

Loc Qty

Loc Code

FP-A

13

110835

13

ST291

931

115108

631

117423

300

AN960JD10L

NAS1149D0332J

Purchased

No

105

Each

0.0000

40

80



Washer

MS27130-S30

Purchased

No

105

Each

216.0000

4

8



Insert

Location

Loc Qty

Loc Code

ST293

216

100154

216

Monday, June 06, 2011 10:38:49 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

REFERENCE ONLY**32.2 WEIGHT AND BALANCE**

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

32.4 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
1	1	D2746	WEARPLATE
1	1	D2656-31	WEARPLATE
1	1	D2656-13	WEARPLATE
5		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
40	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
40	40	MS27039-1-08	SCREW
40	40	AN960JD10L	WASHER

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DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

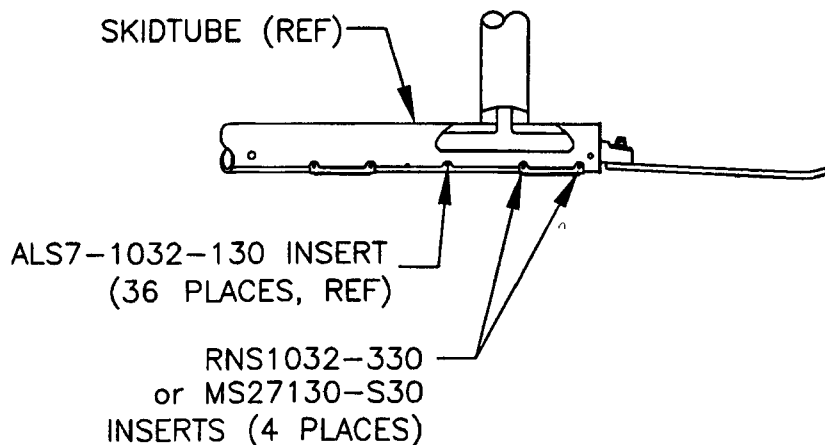
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT



NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: NOV 19, 2001
CERT. NO.: SH01-25
ISSUE NO.: 1

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